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Referring to Figure 8, after outside sweep core 52 and insert portion 50 are clear of mold cavity block 38, first slide assembly 40 is translated in it's entirety, for example, generally normal to the direction of the first retraction, (including outside sweep core 52, inside sweep core 54 and insert portion 50) until undercut portion 68 of inside sweep core 54

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is clear of lesser curvature 30. At this point, first slide assembly 40 is retracted linearly to withdraw inside sweep core 54 from the inside of lumen 14.